

Quick Silver

Work Order ID 51850



Page 1

Tuesday, September 08, 2009 8:39:57 AM

Item ID:	D206-667-101QS	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Crosstube Fwd -QUICK SILVER PAINT					
Start Date:	9/4/2009	Start Qty:	1.00		Cust Item ID:	
Required Date:	9/11/2009	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-141	Rev C								

210		0.00							
	SprayPaint								09 09 09
SprayPaint	Memo	0.00							
Spray Painting	PULL FROM STOCK: 50081								
	1 X D206-667-101 B 50081 CHG003								
	SCUFF TUBE LIGHTLY TO RE-PAINT IMRON QUICK SILVER B 112614								
	PER QSI005								
	APPLY IMRON CLEAR B 112632								
220	QC14- Inspect Spray Paint	0.00							
									09.07.10
QC	Memo	0.00							
Quality Control									



DART			
Dart Aerospace Ltd.			
270 ABERDEEN ST			
HAWKESBURY ON CANADA K6A 1K7			
TC APPROVAL # 09-89		TEL: 1-613-632-5200	
P/N	D206-667-101	CHG	CHG003
DESC	Crosstube Fwd High	STC	SH01-5
LOT	B50081	STC	SR01304NY
MODEL	Bell 206A/B	STC	
MADE IN CANADA			
D2729-1			




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Item ID: D206-667-101QS Accept  Setup Start 
 Revision ID:  Stop 
 Item Name: Crosstube Fwd -QUICK SILVER PAINT
 Start Date: 9/4/2009 Start Qty: 1.00  Cust Item ID:
 Required Date: 9/11/2009 Req'd Qty: 1.00  Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging	ENSURE ORIGINAL KIT IS PACKAGED WITH TUBE								
280 	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
290 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	RE-PACKAGE PER PPP USING NEW B/N NEW LABELS REQ'D								

5 09/09/14
 CHG003
 Rec D

9/9/14 (12) SY PL 09-9-11

Work Order ID 51850

Tuesday, September 08, 2009 8:39:57 AM

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Item ID: D206-667-101QS

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Fwd -QUICK SILVER PAINT

Start Date: 9/4/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 9/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/14

WF 09.09.
14

Picklist Print

Page 1

Tuesday, September 08, 2009 8:39:56 AM

Work Order ID: 51850



Parent Item: D206-667-101QS



Parent Item Name: Crosstube Fwd -QUICK SILVER PAINT

Start Date: 9/4/2009

Required Date: 9/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D206-667-101RevC		Manufactured	No				Each	7.0000	1.0000			

Crosstube Fwd

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	3	
16409	0	
16411	0	
29101	1	
29258	1	
29263	1	
35571	1	
35894	1	
50081	1	
50094	1	

m/ 09 09 09

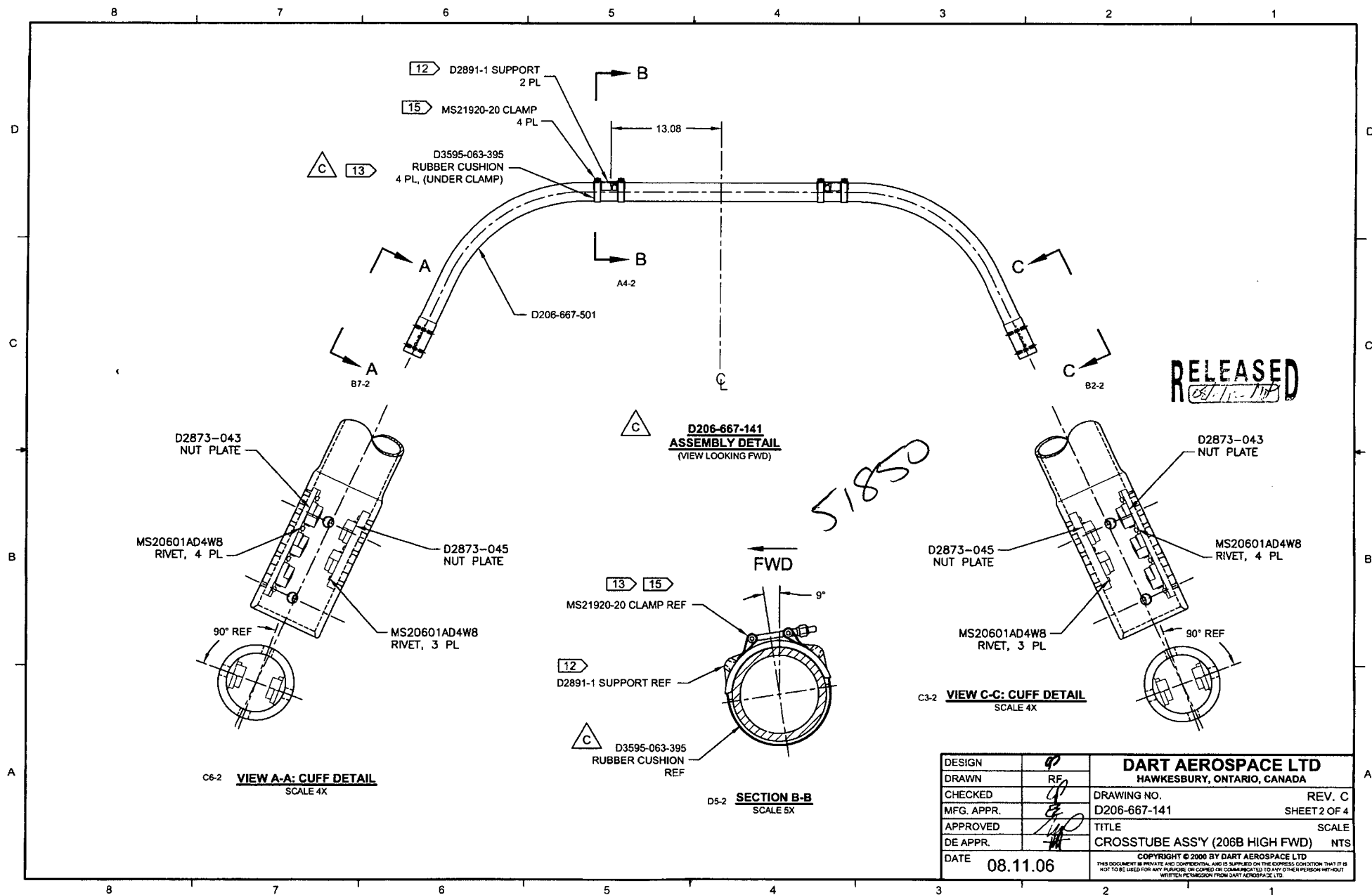
Item	Qty -141	Part Number	Description
1	X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
2	1	D6001-105	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

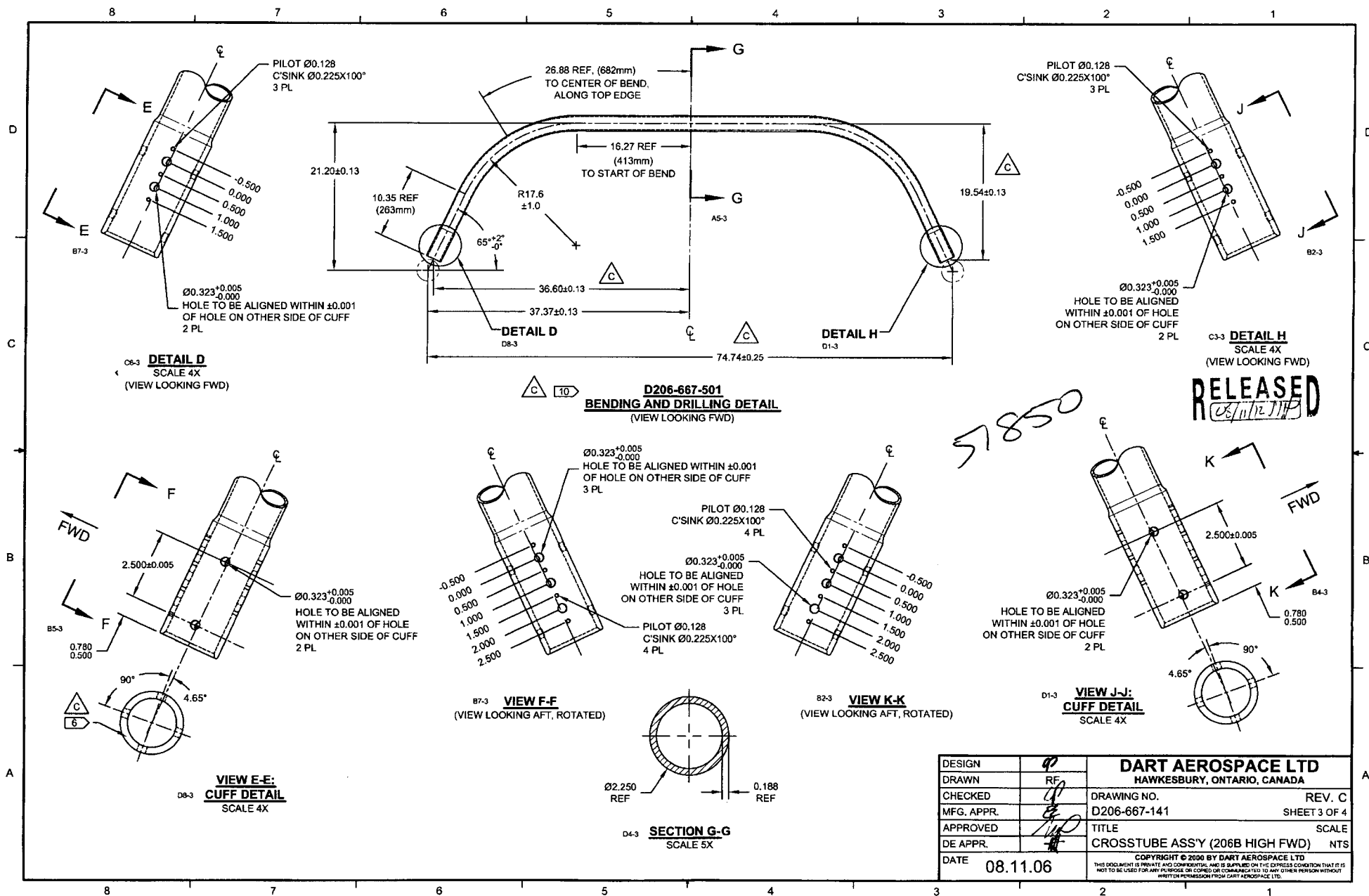
- 1) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 11.3 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

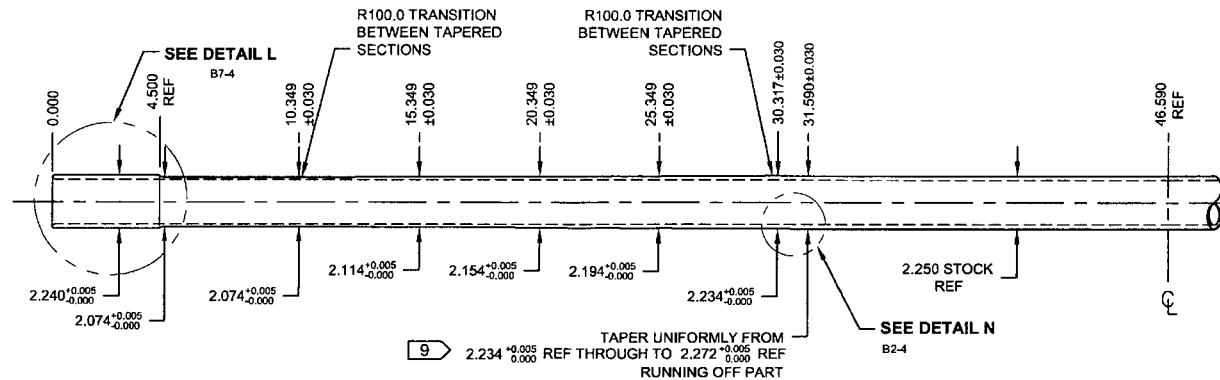
RELEASED
02/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C4-3, C5-3 & D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-141	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (206B HIGH FWD)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

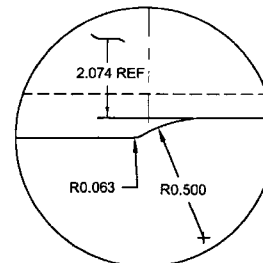


DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	GP	D206-667-141	SHEET 2 OF 4
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

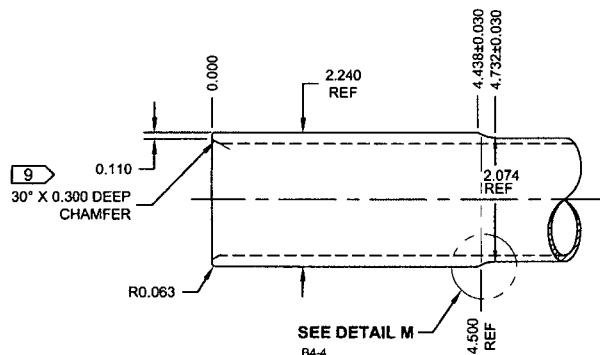




TURNING DETAIL

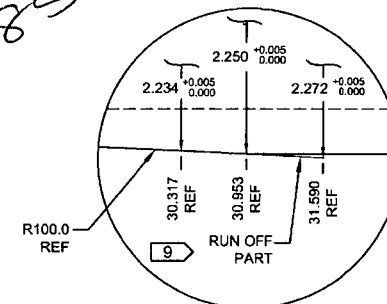


DETAIL M:
A6-4 CUFF TRANSITION
NOT TO SCALE



DETAIL L:
D7-4 CROSSTUBE CUFF
NOT TO SCALE

51850



DETAIL N:
C4-4 TAPER RUN-OFF
NOT TO SCALE

RELEASED
02/11/12

DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4	DRAWING NO.	REV. C
MFG. APPR.	4	D206-667-141	SHEET 4 OF 4
APPROVED	4	TITLE	SCALE
DE APPR.	4	CROSSTUBE ASSY (206B HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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Work Order ID 51850

Tuesday, September 08, 2009 8:39:57 AM

Page 1

Item ID: D206-667-101QS

Accept

Revision ID:

Item Name: Crosstube Fwd -QUICK SILVER PAINT

Start Date: 9/4/2009 Start Qty: 1.00

Required Date: 9/11/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D206-667-141

Rev C

210



SprayPaint

0.00

SprayPaint

Memo

0.00

Spray Painting

PULL FROM STOCK: 50081
1 X D206-667-101 B

SCUFF TUBE LIGHTLY TO RE-PAINT IMRON QUICK SILVER B 112614
PER QSI005

APPLY IMRON CLEAR B 112632

09 09 09

220



QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

09 09 09

DART
Dart Aerospace Ltd.
10000 100th Ave.
Edmonton, Alberta T6E 6C1
TEL: 781-313-5200

D206-667-101 QS
Crosstube Fwd High
B50081
Bell 206A/B

CHG003
SH01-5
SR01304NY

MADE IN CANADA
D2729-1

Work Order ID 50081

July 08, 2009 11:40:36 AM

Page 1

Item ID: D206-667-101

Accept

Setup Start

Revision ID: C

Stop

Item Name: Crosstube Fwd

Start Date: 7/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-141	Rev C								

100

0.00

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-101

CHG003

110

0.00

Packaging

Packaging

Memo

0.00

Packaging

120

0.00

BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT _____

DP 9-7-14

Work Order ID 50081

Page 2

July 08, 2009 11:40:36 AM

Item ID: D206-667-101

Accept

Setup Start

Revision ID: C

Stop

Item Name: Crosstube Fwd

Start Date: 7/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC15- Crosstube Dimensional Check	0.00				1	0		<i>[Signature]</i>
QC	Memo	0.00							
Quality Control									
140	Crosstubes	0.00							
Crosstubes	Memo	0.00							
Crosstubes	1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes. □3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. □4-Drill pilot holes using dr								
150	Crosstubes Chemical Conversion	0.00							
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes									

Handwritten:
AUM 9-7-13
MA 09-07-15
(14)

Handwritten:
-AUM 9-7-16

July 08, 2009 11:40:37 AM

Setup Start

Stop

Start Date: 7/10/2009 **Start Qty:** 1.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 **QC3- Inspect Part Finish**

0.00

$$\Rightarrow \delta_{01/07/10}$$

✓

6

QC Memo

0.00

Quality Control

170 QC5- Inspect part completeness to step on W/O

0.00

$$\Rightarrow 509/07/16$$

10

2

QC Memo

0.00

Quality Control

180 Outsource process - NDT per QSI038 4.1

0.00

CZ 09/07/16 ①

Outsource2 Memo

0.00

Outsource process - NDT Liquid Penetrant Inspection as per QSI 038Or ☐ Issue P/O: 10079 LPI as per ASTM 1417 ☐ Level 2 Attach copy of NDT results to work order

Work Order ID 50081

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Page 4

Item ID: D206-667-101

Accept

Setup Start

Revision ID: C

Item Name: Crosstube Fwd

Stop

Start Date: 7/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Ensure copy of NDT results attached to work order.								

200	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control	Inspect for damage & ensure results are as per Dwg D206-667-103								

210	SprayPaint	0.00							
SprayPaint	Memo	0.00							
Spray Painting	1-Prime inside and outside crosstube as per QSI 005 4.2.1□*****Let tube sit up right for 30mins before hanging*****□P4500-P-23 Base Batch: <u>111/34</u> □P4500-C-23 Catalist Batch: <u>111/34</u> □Start time: <u>10:00</u> F								

ml 09 07 22 ①

PC 4/2/17 (1)

BT 09-07-20

P70
See Dwg
backs. 112

Work Order ID 50081

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Item ID: D206-667-101

Accept

Setup Start

Revision ID: C

Stop

Item Name: Crosstube Fwd

Start Date: 7/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

220 QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

Wrap in plastic bag to protect from scratches

RT 09-07-23

230

0.00

SprayPaint

SprayPaint

Memo

0.00

Spray Painting

1-Paint outside crosstube with White Imron as per QSI 005 4.2

Batch: 112073 □ Imron 125S activator

Batch: 112073 □ Start: 12:30

⇒ M 09 07 23 ①

240

QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

RT 09-07-23

July 08, 2009 11:40:37 AM

Item ID: D206-667-101

Setup Start

Stop

Item Name: Crosstube Fwd

Start Date: 7/10/2009 **Start Qty:** 1.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

250

0.00

Crosstubes

Crosstubes

Memo

0.00

Crosstubes

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI

015. Let cure for 12h after installation and prior to packaging. Note: (3) top

holes should be facing up. □ A/R Magnobond 6398 :

Torque clamps to 80-100 in lb□3

260

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

270

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

Work Order ID 50081

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Item ID: D206-667-101

Accept

Setup Start

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Stop

Item Name: Crosstube Fwd

Start Date: 7/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

280 QC4- 100% Inspect kits for completeness

0.00

2) 8096/27

(4) 6

QC Memo

0.00

Quality Control

290

0.00

Packaging

Packaging Memo

0.00

Packaging Identify and pack for shipping as per PPP D206-667-
101 □ Location: _____ □ PPP Rev: _____

09/07/27 (1)

300

QC21- Final Inspection - Work Order Release

0.00

QC Memo

0.00

Quality Control

09/07/28

MF 09-07-27

Picklist Print

Page 1

July 08, 2009 11:40:36 AM

Work Order ID: 50081

Parent Item: D206-667-101RevC

Parent Item Name: Crosstube Fwd

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516 Washer		Purchased	No			100 270	Each	1,603.000	18.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1603	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	296	
112082	1000	

D206-667-
101TRNRevC

Manufactured No

Crosstube Turning Detail

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
FG	2	
37980	1	
37981	1	

112082 9/7/24 SE

IX MP 09-07-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 08, 2009 11:40:36 AM

Page 2

Work Order ID: 50081

Parent Item: D206-667-101RevC

Parent Item Name: Crosstube Fwd

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2873-043RevA		Manufactured	No			250	Each	37.0000	2.0000			

Nut Plate Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	37	
45370	20	
45422	17	

ml ml 09 07 20 (2)

D2873-045RevA		Manufactured	No			250	Each	35.0000	2.0000			
---------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Nut Plate Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	35	
45210	15	
46772	20	

ml ml 09 07 20 (2)

13595-063-395 qty: 4

Batch # : 44667 ml 09 07 23

Route seq: 250

09/07/15

July 08, 2009 11:40:36 AM

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

July 08, 2009 11:40:36 AM

Work Order ID: 50081

Parent Item: D206-667-101RevC

Parent Item Name: Crosstube Fwd

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2891-1RevA1		Manufactured	No			250	Each	65.0000	2.0000			

2.25 Support

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 65

40336 1

41198 20

43880 20

45935 4

46159 20

~~not used~~ 09 07 23

MS21920-20

Purchased

No

~~250~~
270

Each 91.3000 4.0000

Clamp (per MIL-DTL-8783C)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 91.3

103478 2

106484 12

109269 9.3

110536 18

111281 50

~~not used~~ 09 07 23

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

July 08, 2009 11:40:36 AM

Work Order ID: 50081

Parent Item: D206-667-101RevC

Parent Item Name: Crosstube Fwd

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-30A		Purchased	No			280 270	Each	93.0000	4.0000			
BOLT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

93

110467

93

Each

119.0000 4.0000

110467

9/17/24 se

AN5-32A

Purchased

No

Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

119

106242

3

106519

4

110363

17

111916

45

112082

50

111916

50

July 08, 2009 11:40:36 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

July 08, 2009 11:40:36 AM

Work Order ID: 50081

Parent Item: D206-667-101RevC

Parent Item Name: Crosstube Fwd

Start Date: 7/10/2009

Required Date: 7/31/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S AN5-7A NO		Purchased	No			280 270	Each	53.0000	10.0000			
Bolt												
S												
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				53				
					110625			7				
					111668			46				
MS20601-AD4W8		Purchased	No			280 250	Each	156.0000	14.0000			
RIVET												
				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				156				
					108521			100				
					110399			56				
S MS21042L5 24		Purchased	No			280 270	Each	787.0000	4.0000			
Nut												
S				<u>Warehouse</u>	<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>			
				Main Warehouse								
				ST				787				
					110382			10				
					111127			277				
					111636			500				

111668 9/7/24 SV

mt mt 09 07 20

111127 9/7/24 SV

July 08, 2009 11:40:36 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

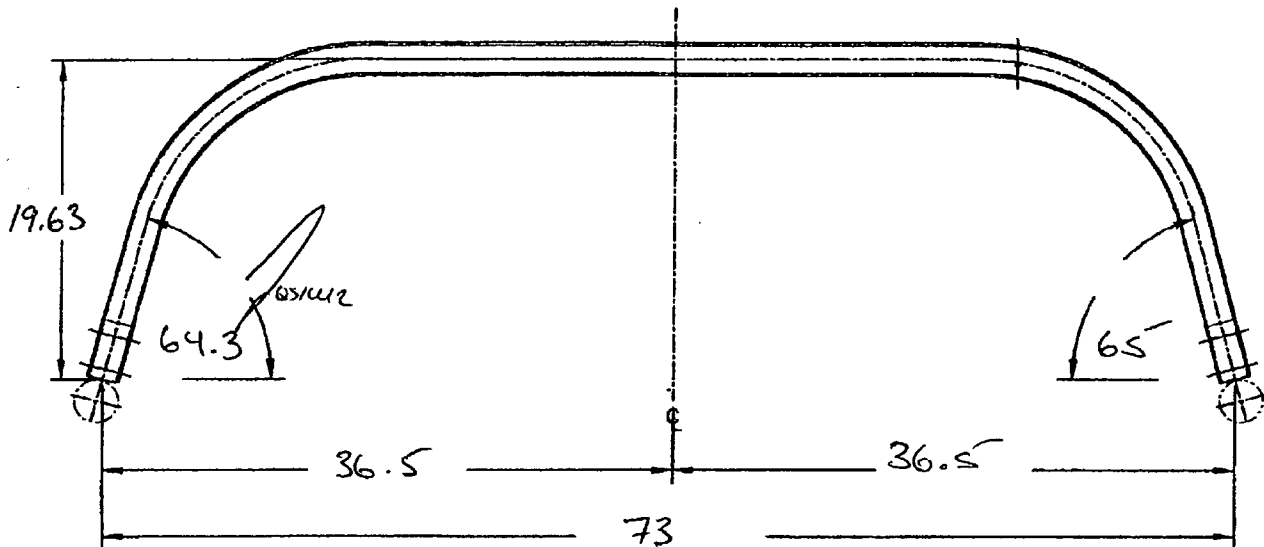
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50081
Description: Crosstube High Fwd (206B)		Part Number:	D206-667-107
Inspection Dwg: D206-667-141		Rev: <i>B C</i>	Page 1 of 1

Required Dimension	Min	Max
Height	19.48 41	19.88 67
1/2 Span	36.54 47	36.86 73
Angle	65	67
Total Span	73.08	73.22 46

72.54

73.2 mm



Comments
Tube fits well into the ring.

QC15 Inspection	<i>OS11412</i>
Date	<i>05.07.15</i>

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

Item	Qty -141	Part Number	Description
1	X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
2	1	D6001-105	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS93028-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 83.18±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-141" AND BATCH NUMBER ON INSIDE OF CLIFF USING VIBRATING STYLUS.
- 7) WEIGHT: 11.3 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

50081

RELEASED
08/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C4-3, C5-3 & D3-3); RELOCATED FLAG #8 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-141	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (206B HIGH FWD)	NTS
DE APPR.	RF	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DATE	08.11.06		

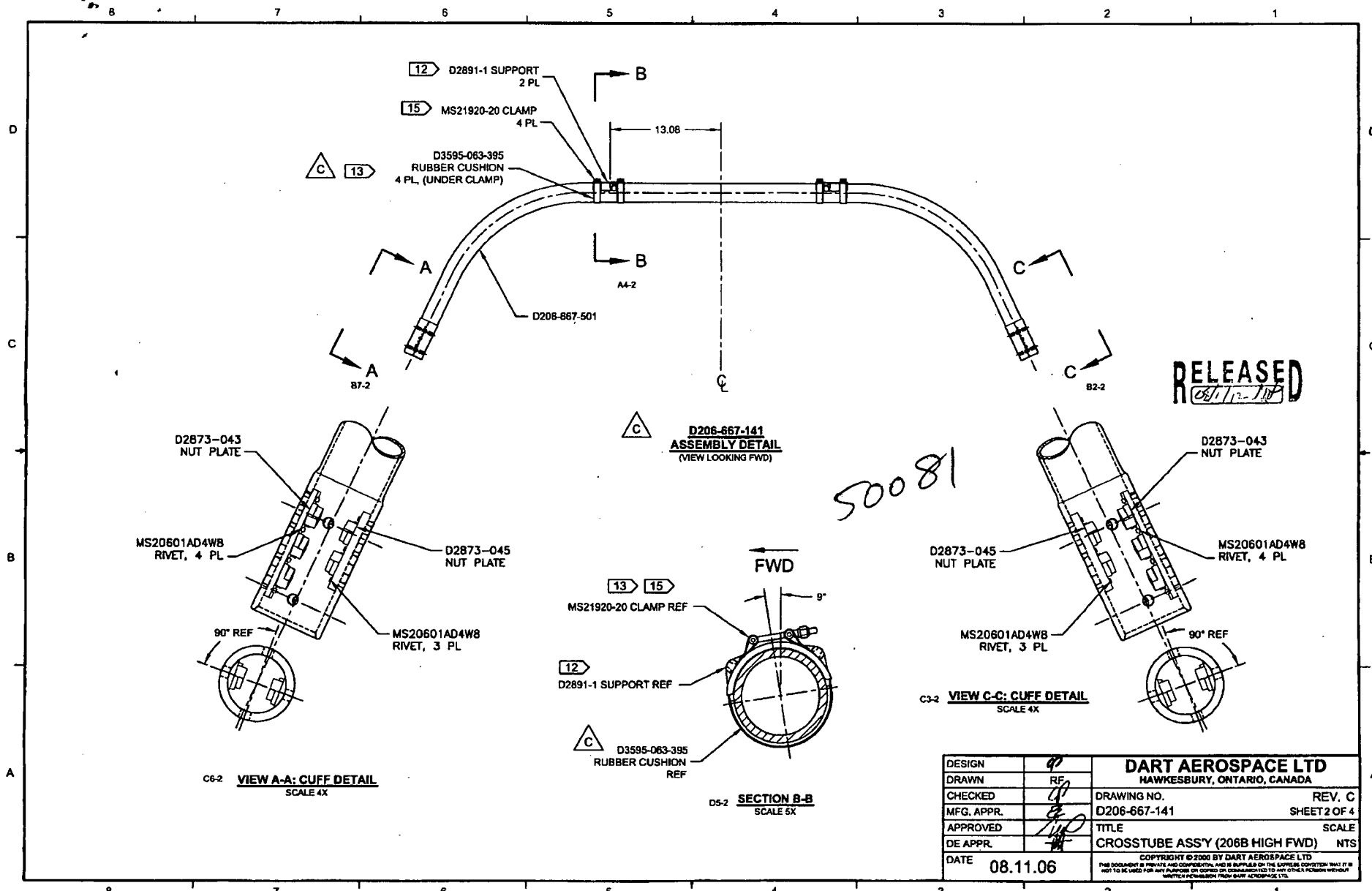
W/O: 50081		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/07/20	200	change to QC 5 for inspection. perm change	MS	09/07/20		09/07/20	09/07/20

Part No: D206-667-101 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	9	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	EP	D206-667-141	SHEET 2 OF 4
APPROVED	THP	TITLE	SCALE
DE APPR.	THP	CROSSSTUBE ASSY (206B HIGH FWD)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE SUPPLIER'S CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

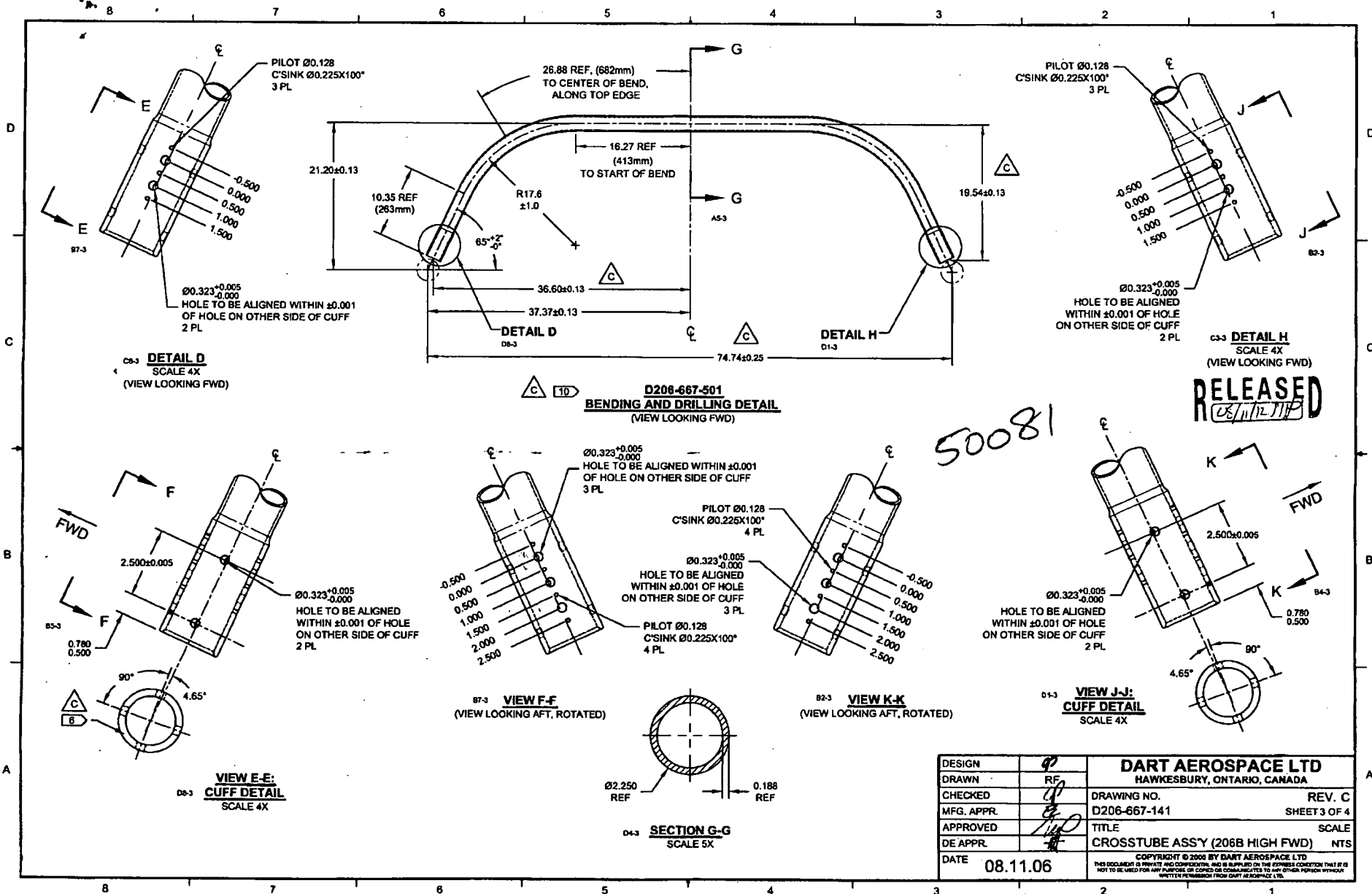
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



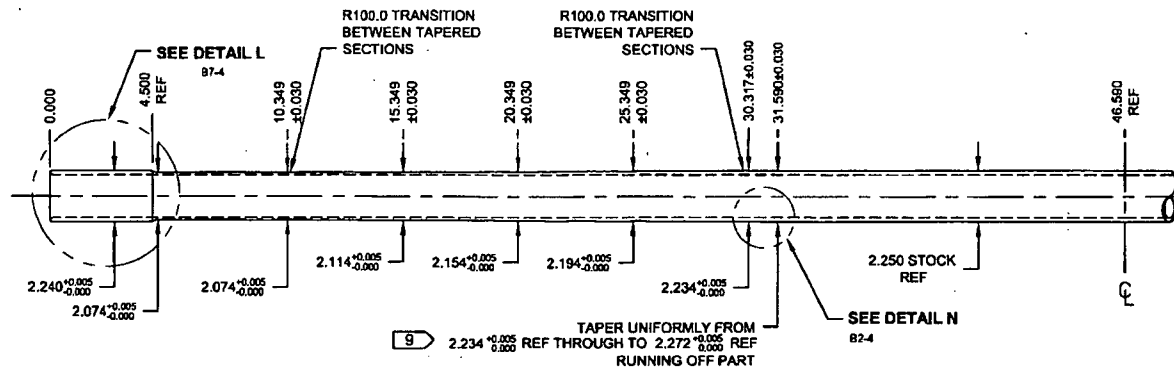
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

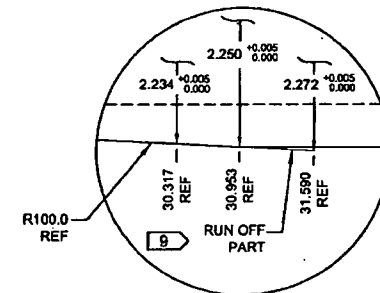
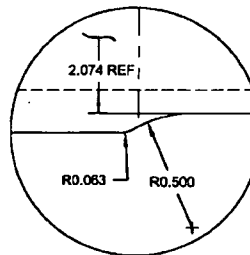
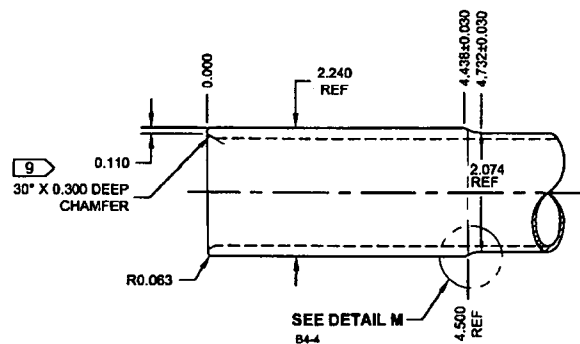
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



TURNING DETAIL



DESIGN	97	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	EP	D206-667-141	SHEET 4 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	HT	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
08/11/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 14943

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE July 16-2009 TIME AM ☒ PM ☐
ATTENTION LINDA/CANTEL ACUREN JOB NO. 188-09-001468
ADDRESS 1270 ADELPHI ST. PO/WO NO. _____
WACKES BURY, ON. K6H 1K7 WORK LOCATION WACKES BURY
ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
PROJECT F.P.I. ON CROSS TUBES
ITEM(S) EXAMINED 6 - X - TUBES

JOB DESCRIPTION PROCEDURE NO. LT-XXX REV./DATE TECHNIQUE NO. LT-XXXX-XXX REV./DATE
PART NO. _____ MATERIAL Aluminum THICKNESS _____
SCOPE WET FLOUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT 100% EXTERNAL

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT ZL 67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LABNO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N _____ CAL DUE DATE DEC 8-2009
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

Work order # _____
1 - 50081 ✓
1 - 50094 ✓
1 - 50045 ✓
1 - 50019 ✓
1 - 50038 ✓
1 - 50044 ✓
No RELAYANT INDICATIONS
WERE FOUND ON THESE
SIX CROSS TUBES

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Zan Tittley DTR # E-27929
TECHNICIAN (SIGNATURE): [Signature] REPORT REVIEWED BY: _____
NAME (PRINT): Mike Jefferson NAME INITIALS
1st TECHNICIAN 2nd TECHNICIAN
CGSB LEVEL II SNT LEVEL _____ CGSB LEVEL _____ SNT LEVEL _____
CGSB REG. NO. 6066 CGSB REG. NO. _____

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

5.0 PARTS LIST

Item	Qty -011	Qty -013	Qty -015	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X									D206-667-011	SPACER BLOCK KIT
		X								D206-667-013	NUT PLATE KIT (-101/-103/-105/-203/-205)
			X							D206-667-015	NUT PLATE KIT (-201)
				X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
					X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
						X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
							X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
								X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
									X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1				1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2					1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3						1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4							1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5								1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6									1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10				*2	*2	*2		*2		D2891-1	SUPPORT
11							*2			D2892-1	SUPPORT
12									*1	D2894-1	SUPPORT
13				*2	*2	*2		*2		D2856-400-694	ABRASION STRIP
14							*2		*2	D2856-400-773	ABRASION STRIP
15									*1	D2856-600-851	ABRASION STRIP
16				*4	*4	*4		*4		MS21920-20	CLAMP
17							*4		*4	MS21920-22	CLAMP
18									*2	MS21920-24	CLAMP
19				4	4	4		4		AN5-32A	BOLT ✓
20							4		4	AN5-34A	BOLT
21				4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5) ✓
22				8	8	8	8	8	8	AN960JD516	WASHER
23									*2	D3190-1	CHAFING SHIELD
30	8									AN4-6A	BOLT
31	8									AN4-7A	BOLT
32	16									AN960JD416	WASHER
33	2									D3193-041	SPACER BLOCK ASSEMBLY
40		2		*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41		2		*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42			2		2					D2872-043	NUT PLATE
43			2		2					D2872-045	NUT PLATE
44		10		10		10				AN5-7A	BOLT ✓
45		10	10		10		10	10	10	AN5-10A	BOLT
46		4	4	4	10	4		4		AN5-30A	BOLT ✓
47		4					4		4	AN5-32A	BOLT
48		18	18	10	12	10	10	10	10	AN960JD516	WASHER ✓
49		4	4		6					MS21042L5	NUT (OR MS21042-5)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/241/143/243, & D407-667-145/245 ASSEMBLIES ABOVE

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Revision: C

Date: 05.07.26

Work Order ID 50081

July 08, 2009 11:40:36 AM

Page 1

Item ID: D206-667-101

Accept

Setup Start

Revision ID: C

Item Name: Crosstube Fwd

Stop

Start Date: 7/10/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D206-667-141	Rev C
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0.00

DOCUMENT CONTROL

Document Control Memo 0.00

Photocopy bluefile and create labels as per PPP D206-667-101 CHG003

bf 27-09 mt 09-09-24

0.00

Packaging

Packaging Memo 0.00

Packaging

6/9/16 (1)

0.00

BENDING MACHINE - CROSSTUBES

MC Bend 2 Memo 0.00

C Alpha 160 Bender

Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT _____

DP 9-7-14